

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010927**Date Inspected:** 27-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # ZPMC Boat

This QA inspector witnessed final tension verification for Corner assembly edge plate splice (North) of Segment 1AE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP8.5: M24 X 75 – DHGM 240020 – 600 NM

OBG # ZPMC Boat

This QA inspector witnessed final tension verification for Corner assembly edge plate splice (North & South) of Segment 1AW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP8.5: M24 X 75 – DHGM 240020 – 600 NM

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

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OBG # TRIAL ASSEMBLY YARD (5AE-5BE)

SMAW Process:

Welding of weld joint – 003 located on PCMK OBW5A, bottom panel transverse splice weld. Welder is identified as 048617. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF UT repair report UT-5E-004 dated 8th Dec. 2009. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.Y locations are identified as 5200, 5400, 4600, 3820 and 3685mm.

OBG # TRIAL ASSEMBLY YARD (5AE-5BE)

SMAW Process:

Welding of weld joint – 002 located on PCMK OBW5A, Side panel transverse splice weld. Welder is identified as 048617. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF UT repair report UT-5E-002 dated 22nd Oct. 2009. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.Y locations are identified as 580mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
